

Work Order ID 100043

April-17-13 8:09:35 AM

\*100043\*

Page

Item ID: D4422-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Shim

Start Date: 4/17/13 Start Qty: 8.00

\*8\*

Cust Item ID:

Required Date: 5/03/13 Req'd Qty: 8.00

\*8\*

Customer:

Reference:

Approvals: Process Plan: MCT

Date: 13-04-17 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4422

A

100

0.00

\*100\*

Small Fab

Memo

0.00

Small Fab

Shear as per dwg D4422

110

QC6- Inspect dimensions to drawing

0.00

\*110\*

QC

Memo

0.00

Quality Control

115

Chemical Conversion Coat per QSI005 4.1

0.00

\*115\*

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 100043

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\*100043\*

Page 2

Item ID: D4422-3

Revision ID:

Item Name: Shim

Start Date: 4/17/13

Start Qty: 8.00

\*8\*

Required Date: 5/03/13

Req'd Qty: 8.00

\*8\*

Reference:

Accept

\*N900040100\*

Setup Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

117

QC7-Inspect Chemical Conversion Coat

0.00

\*117\*

QC

Memo

0.00

Quality Control

11x 8 m/f 13/06/20

120

Identify as per dwg & Stock Location: 5T108

0.00

\*120\*

Packaging

Memo

0.00

Packaging

11x 11.10. 13-06-21

SP

130

QC21- Final Inspection - Work Order Release

0.00

\*130\*

QC

Memo

0.00

Quality Control

MCS 13-06-24

pl 13-06-21

# Picklist Print

April-17-13 8:09:40 AM

Page 1

Work Order ID: 100043

Parent Item: D4422-3

Parent Item Name: Shim

\*100043\*

\*D4422-3\*

Start Date: 4/17/13

Required Date: 5/03/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP revA 11.06.30 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

sf

232.8625

0.195453

\*\*

**\*M6061T6S 063\***

6061-T6 .063 Sheet

FF 13-06-10

Location

431

Loc Qty

Loc Code

MAT021

125 ~~574~~

232.8625

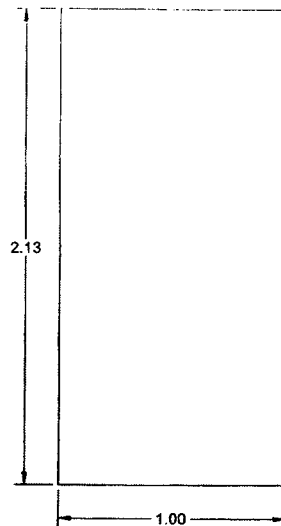
123135

120.5625

124003

112.3

0.2687



**D4422-X SHIM**



P/N	"T" THICKNESS
D4422-1	0.125
D4422-3	0.063

UNCONTROLLED COPY  
WORK ORDER

100043-MCS

13-04-17

RELEASED  
2011-07-06

**NOTES:**

**1) MATERIAL:**

D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11  
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.125

OR

6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8

OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221

REF DART SPEC M6061T6S

REF DART SPEC M6061T6S

D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11  
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1

7) WEIGHT: D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

A	NEW ISSUE	MB	11.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.22		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4422</b>	REV. A
TITLE <b>SHIM</b>	SCALE NTS
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